Work Order ID | 100158 | R 🔩 🕾 *100158*

April-18-13 1:19:55 PM

Item ID:

D4030-041

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

4/18/13

Long Basket Assembly (350)

Cust Item ID:

Customer:

Required Date: 5/02/13

Start Qty: 1.00 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: MLJ Date: 13-04-18 Tooling:

Date:

Run

QC:

Date: _____ SPC (Y/N):

Date:

Stop

1 & Bl 13-4-25.

			_								
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	i .	•								
D4030	C									20	
100	Pick Kit		,	0.00						//	
100 Packaging	Memo			0.00		•			//	13/4	100 W
Packaging				•						//	

110

Assemble as per dwg

110 HandFinish

Memo

0.00

Hand Finishing

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly

sand area for label, apply label ****

120

QC5- Inspect part completeness to step on W/O

120

Quality Control

Memo

											DQA:	Date:	
NCR:	⁄es	/ No				WORK ORDER NON-C	100	VFORM	AANCE / UPDA	ATE			·
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR Olde	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	۷o.					Scrap		Y	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o. ِ				,	Work Order Update			Large Fab	Composite		Supplier	
				·	Deseri	ntion of work and a undata	لِـــ	Initial	Actio		Sign &	Г	T
Root	l	D-4-	C+	O4		ption of work order update or Non-conformance	1		Descrip		Date	Verification	QC Inspector
Cause	-	Date	Step	Qty	(or Non-conformance	Cn	nief Eng	Descrip	Mon	Date	Vernication	QC IIIspector
Doc/Data	\Box												
Equip/Tooling	\vdash												
Operator	-										ļ		
Material	-												
Setup Other	\vdash												
Process	\vdash												
Supplier	\vdash	٠.											
Training	H												
Unapproved	H											1	
				<u>. </u>	L	F	AUL	T CATE	GORY	······································	<u> </u>		
Landi	ng G	iear				General		145					
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	П	Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Da					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped. Burrs] Instruct	ions Incomplete/Un	nclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs Contamination					Contamination					Part Moved		
	Heat Treat Countersink							Mislabe	led		Positioned Wrong		
		Inspection	n Strip in	Tube		Cut Too Short	Short Misread Power Loss/Surge Othe						Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID. 100158

April-18-13 1:19:55 PM

100158

Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	4/18/13	Assembly (350) Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Accept	*N900 Cust Item Customer:		10	N *	Setup St	art top	*NS1* *NS2*	
Approvals:		in:	Date:		•	ate:				art op	*NI *NI	R1* R2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging)	Operation Description Identify as per dwg & S	tock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty			eject imber	Insp. Stamp
140 *140* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00					13	K	16	**

pl 1305-21

Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS Rework Skid-tube Crosstube Water Jet Er	
Work Order: Rework Skid-tube Crosstube Water Jet Er	
Rework Skid-tube Crosstube Water Jet Er	
	gineering
Part No. Scrap Machining Small Fab Prod. Eng. Coor.	Quality
Use-as-is Thermoforming Finishing Rec/Store/Packaging	Other
NCR No Work Order Update Large Fab Composite Supplier	
Root Description of work order update Initial Action Sign &	
	QC Inspector
Doc/Data Doc/Data	
Equip/Tooling .	
Operator	
Material	
Setup Others	
Other	
Process Process	
Supplier	
Training	
Unapproved	
FAULT CATEGORY	
Landing Gear General Bending Bending Bend Grain Ovalized Pres	sure/Forced
	perature/Cure
I REPORT PROCESS TO CONTROLLED REPORT OF THE PROCESS OF THE PROCES	•
Cracks Broken/Damaged Inspection Incomplete Part Incorrect We	
Cracks Broken/Damaged Inspection Incomplete Part Incorrect We Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wro	ong Stock Pulled
Cracks Broken/Damaged Inspection Incomplete Part Incorrect We Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wro	
Cracks Broken/Damaged Inspection Incomplete Part Incorrect We Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wroman Cuffs Contamination Maintenance Part Moved Positioned Wrong	ong Stock Pulled
Cracks Broken/Damaged Inspection Incomplete Part Incorrect We Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wro	ong Stock Pulled

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-18-13 1:19:58 PM

Work Order ID: 100158

100158

Parent Item:

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as

per dwg revB DD 10.04.20 verified by:EC

IPP Rev:C as per dwg

revC DD 10.08.18 verified by:EC

IPP Rev D 12.03.27 per NCR12-

1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	19.0000					
D4086-20 Placard, Max Load	ገበ							1210000	**				
				Location	<u>1</u>	Loc	<u>Qty</u>	Loc Code					
				ST093			19						
					88611		5		_		_		
					96251		4		_		-		
D2520					98519		10		7	1625	7	_	
D2530		Manufactured	No			100	Each	15.0000	1	1			
D2530 Handle Weldment									**			/	·
				Location	!	Loc	Qt <u>y</u>	Loc Code				1	
				ST205			10						
	•				87086		10			<u> </u>	7		
				ST255			5		_		-		
					86369		5		F	636	9		
D2535		Manufactured	No			100	Each	50.0000	2	2 _	_		
D2535 Spring									**			<u></u>	4/20
				Location		Loc (Qty .	Loc Code					′′
				ST011			50						
					96248		50		-6	1620	£		

				DQA:	 Date: _	
ICR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

						0			QA Closed:	Date:		
Work Orde	ar.	·,	<u> </u>		DISPOSITION			AGAINST DI	EPARTMENT,	/PROCESS		
Part N	No				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	Initial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data										•		
Equip/Tooling												
Operator												
Material		1										
Setup												
Other						<u> </u>			1			
Process			•									
Supplier												
Training												
Unapproved	<u> </u>		<u> </u>	<u> </u>			CORY	<u> </u>		<u> </u>		
						AULT CATE	GORY					
Landi	ng Gear				General	Grain		Ĺ.	Ovalized		Pressure/Forced	
	Bending			0/5	Bend BOM/Route	Hardwa		<u> </u>	Over/Under	toloranco	Temperature/Cure	
	Cracks	lot Conce	ntric to	^{0/3} -	Broken/Damaged		ion Incomplete	· -	Part Incorre	-	Weld	
	⊢ ⊣	/Crimped			Burrs	⊢ ·	ions Incomplete/l	Jnclear –	Part Lost/M		Wrong Stock Pulled	
	Cuffs	, crimpeu.	•	-	Contamination		enance	-	Part Moved] 0.000	
		Cuffs Contamination Heat Treat Countersink					eled	<u> </u>	Positioned V	Vrong		
	Inspection Strip in Tube Cut Too Short					Misrea		<u> </u>	Power Loss/		Other	
	Ripples				Drill Holes	Offset		L			·	
	Torque Waves in Extrusion Drawing					Out of Calibration						
	Turning Sequence Finish					Out of	Sequence					
	Wave/T	wist in Tul	e .		Folio	Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order 1D: 4100158

100158

Parent Item:

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured

100

Each

96.0000

**

Bushing

D3913-041

D3914-041

D3917-3

Long Basket Base Assemby, 350

D3914-041 Long Basket Lid Assembly (350)

D3917-3

		Location	· <u>L</u>	oc Qty	Loc Code			
		ST008		24				
		99011		24				
		ST011		72				
		92711 94713		8 40			747/3	
Manufactured	No	98426	100	24 Each	0.0000	1	1	
		100/66		,		**		BL 13-4-25,
Manufactured	No		100	Each	0.0000	1	1 .	
		100174				**		bl 13-4-25.
Manufactured	No		100	Each	90.0000	6 **	6	
						^ ^		(12/1/2

60

Washer Location Loc Qty Loc Code ST072 92514 94136 5. 94643 24

										DQA:	Date:	
NCR: Y	es / No)			WORK ORDER NON-O	100	NFORN	MANCE / UPDATE		QA Closed:	Date:	
Morle Orde	~ · ·	. 			DISPOSITION			AG	AINST DEI	PARTMENT	/PROCESS	
Work Orde					Rework Scrap Use-as-is	1	f Therm	Machining Sma	sstube all Fab		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	10				Work Order Update]		Large Fab Com	posite		Supplier	J
Root				Descri	ption of work order update	1	Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator						1						
Material										:		
Setup												
Other				ŀ								
Process												
Supplier		1									•	
Training												
Unapproved												
					F	AUL	T CATE	GORY				
Landi	ng Gear				Genera!		-			,	_	-
	Bendin	g		L.	Bend		Grain			Ovalized		Pressure/Forced
:	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	<u> </u>	Part Moved		
	Heat T	reat			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspec	tion Strip ir	1 Tube		Cut Too Short		Misread	ľ		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Order ID: 100158

100158 D4030-041

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13 Start Qty: 1.00

Required Date: 5/02/13

Required Qty: 1.00

D3953-3

Manufactured

100

Each

34.0000

Loc Code

58.0000

**

**

Gas Spring Stud, Lid

Location	Loc Qu	<u>ty</u>
GA		1
8759	2	1
ST076		21
8849	1	14
9474	1	7
ST176		12
9916)	12
	100	Each

D3953-7

D3953-9

Manufactured No

Manufactured

Spring Spacer

Location	Loc	c Qty	Loc Code	
ST076		58		
94669		34		
99148		24		
	100	Each	65.0000	
				**

45

Gas Spring Washer

Loc Qty Location ST076 94719 20

95127

Loc Code

April-18-13 1:19:58 PM

Shop Packet Print

Page 3

NCR: Ye	es / No			•	WORK ORDER NON-O	CONFO	RMANCE / UP	DATE	QA Closed:	Date	:		
Work Ordei	·:				DISPOSITION	<u> </u>		AGAINST DE	PARTMENT				
Part No	o				Rework Scrap Use-as-is	The	Skid-tube Machining ermoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR N	o			· ·	Work Order Update] '''	Large Fab	Composite	e Supplier Supplier				
Root				Desc	ription of work order update	Initia	Ac	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Desc	ription	Date	Verification	QC Inspector		
Doc/Data													
quip/Tooling													
Operator						1							
Material		1											
Setup													
Other													
Process	1										·		
Supplier													
Training				·									
Unapproved													
			•		F	AULT CA	TEGORY						
Landin	g Gear			ŗ	General					<u>.</u>			
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced		
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure		
	Cracks			Ī	Broken/Damaged	Inspe	ection Incomplete		Part Incorre	ct	Weld		
Ī	Crushed/	Crimped.		: [Burrs	Instr	uctions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled		
Γ	Cuffs			, [Contamination	Mai	ntenance		Part Moved				
r	Heat Trea	it		. [Countersink	Misla	abeled		Positioned \	Vrong			
	Inspection Strip in Tube Cut Too Short					Misr	ead		Power Loss/	Surge	Other		
<u> </u>	Ripples in Bend Drill Holes					Offse	et		-				
F	Torque W		extrusio	n	Drawing	Out	of Calibration		****				
	Turning S			.	Finish	Out	of Sequence						
	Wave/Tw			.	Folio	Outside Dimensions							

DQA:

Date:

Work Order ID: 100158

100158

Parent Item:

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13 Start Qty: 1.00

Required Date: 5/02/13

2

Required Qty: 1.00

D3953-17

Manufactured

No

100

Each

44.0000

**

Gas Spring Spacer

<u>Location</u>	<u>Lo</u>	c Qty	Loc Code
ST076		44	
94578		12	
97100		12	
97696		20	
	100	Each	16.0000

D3953-19

D3953-21

Manufactured

Manufactured

16.0000

Loc Code

**

**

**

D3953-19

Gas Spring Bracket

Manufactured	No

No

92819 97691

Location

ST077

4 12 100 Each

Loc Qty

16

18.0000

Gas Spring Bracket

Location	<u>n</u>		Loc Qty	Loc Code
ST075			12	
	97714		12	
ST077			6	
	94146		6	
		100	Each	16.0000

D3969-3

Spring (Basket Lid)

Location	Loc Qty	Loc Code
ST262	10	
91844	10	
ST272	. 6	
97050	6	

		DQA:	Date:
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

IVCII.	103	, 110				TO THE STATE OF TH	_				QA Closed:	Date	3.
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I						Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	1	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		:	Ì										
Operator													
Material													
Setup			1										
Other													
Process													
Supplier													
Training													
Unapproved		•									<u> </u>	<u> </u>	
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General					_	۳-	
		Bending			L.	Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	ire	<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	<u></u>	Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled	L	Positioned \	Wrong _	
		Inspection	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	/Surge	Other
		Ripples in	Bend			Drill Holes		Offset			·····		
		Torque W	Vaves in E	Extrusio	n	Drawing		Out of	Calibration				
		Turning S	equence			Finish		Out of :	Sequence				
		Wave/Tw	ist in Tub	эe		Folio		Outside	Dimensions				•

Wave/Twist in Tube

Picklist Print

April-18-13 1:19:58 PM

Work Order ID: 100158

100158

No

No

No

No

Purchased

Purchased

Purchased

Purchased

Parent Item: D

D4030-041

D4030-041

123759

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

AN3-14A

Bolt

AN3-14A

 Location
 Loc Oty
 Loc Code

 ST512
 87

100

100

87 87

Each

Each

Each

102.0000 2

**

**

**

**

12.3765

AN3-16A

Bolt

AN3-16A

 Location
 Loc Qty
 Loc Code

 GA
 47

117441 47 ST352 55 122407 8 123900 47

152.0000

87.0000

123500

AN5-17A

вон

AN5-17A

 Location
 Loc Oty
 Loc Code

 GA
 36

 117872
 36

100

117872 36 ST337 116 124215 50

124215 50 124805 66 100 Each

124805

*AN4-12

oit

AN4-12

 Location
 Loc Oty
 Loc Code

 ST356
 71

122800 21 124805 50

71.0000

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	AANCE / UPDAT	E			
	16.			The same	444				The same of the sa		QA Closed:	Date	· · · · · · · · · · · · · · · · · · ·
Work Orde	or.		ı I			DISPOSITION			A	GAINST DE	PARTMENT	/PROCESS	
WOIK OIG	-		i			Rework	1		Skid-tube Cr	osstube		Water Jet	Engineering
Part I	No.		I			Scrap	1	1		mall Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is			~ 	inishing	Rec/Sto	re/Packaging	Other
NCR f	No	<u>-</u> <u>-</u>				Work Order Update	_		Large Fab Co.	mposite		Supplier	
Root		i			Descri	ption of work order update	Π	Initial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descriptio	n	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш	1											
Operator	Ш	1	1	}									
Material	Ш	1	-									İ	
Setup	Ш												
Other	Ц	i											
Process	Ц	•											
Supplier		1			- 1								
Training	Ш												
Unapproved			l									<u> </u>	
							AUI	T CATE	GORY				
Landi						General	_	7		_	1	ر -	-
	ш	Bending				Bend		Grain		<u> </u>	Ovalized	_	Pressure/Forced
	-	CentreiNo	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa			Over/Under	⊢	Temperature/Cure
	Ш	Cracks!			L.	Broken/Damaged		-	on Incomplete		Part Incorre	 	Weld
	-	Crushed/	Crimped.		_	Burrs	_	-	ions Incomplete/Uncle	ar	Part Lost/M		Wrong Stock Pulled
		Cuffs				Contamination		Mainte		<u> </u>	Part Moved		
	Ш	Heat Trea	it			Countersink		Mislabe	led		Positioned \		-
	\square	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes	L	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order 1D: 100158

D4030-041

100158

Parent Item:

Parent Item Name: Long Basket Assembly (350)

Purchased

Purchased

Purchased

D4030-041

Start Date: 4/18/13

**

**

72.0000

Required Date: 5/02/13

Start Qty: 1.00

3

Required Qty: 1.00

AN310-4

NUT

AN310-4

Location Loc Qty Loc Code ST342 72

100

122800 2 124221 70

100

Each 86.0000

Each

3

No

No

No

AN310C4

AN310C4

Location Loc Oty Loc Code ST342 86 123831

2 124221 84 100 Each

4,739.000 **

MS21042I3

Nut

MS21042L3

Location Loc Qty Loc Code FP001 3 122141 3 GA 114 122452 114

268

32

55

138

123265 ST506

117885

119017

119075

ST314

NCR: \	res / No				WORK ORDER NON-O	CONFO	RMANCE / UI	PDATE			
									QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT		
Part N					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	Α	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector
Doc/Data		}				-					
Equip/Tooling										ĺ	
Operator											
Material											
Setup		İ									
Other			-								
Process											-
Supplier	\square]	,								
Training											
Unapproved	<u>. </u>	L	<u> </u>			AULT CA	TEGORY		<u> </u>	<u> </u>	
Landi	ng Gear				General	AUL! CA	TEGORT				
Landi	Bending				Bend	Grai	n .		Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to s	o/s	BOM/Route	\vdash	ware	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks			-	Broken/Damaged		ection Incomplete		Part Incorre	⊢	Weld
	Crushed/	Crimped.			Burrs		uctions Incomplete	e/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs	•		_	Contamination	 	ntenance		Part Moved		_
	Heat Trea	it			Countersink	Misl	abeled	<u> </u>	Positioned \	N rong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss,	'Surge	Other
	Ripples in	Bend			Drill Holes	Offs	et	<u> </u>			
	Torque W	/aves in E	xtrusio	n	Drawing	Out	of Calibration				
	Turning S	equence			Finish	Out	of Sequence				

Outside Dimensions

DQA:

Date: ___

Turning Sequence

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100158

D4030-041

Parent Item Name: Long Basket Assembly (350)

100158

D4030-041

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Parent Item:

Purchased

Purchased

Purchased

No

100

Each

337

337

28

Each

Loc Qty

Loc Code

Loc Code

337.0000 **

**

MS21042L5

Nut

No

No

123900

100

137.0000

MS24665-151

Cotter Pin

MS24665-151

GA 17566 ST323 122802 124859

Location

Location

ST506

28 109 59 50 100 Each

Loc Qty

219.0000 **

Cotter Pin

MS24665-300

Location Loc Qty GA 37 37 118234 ST299 182 124555 182 Loc Code

										DQA:	Date:	
NCR: Y	es / No	1			WORK ORDER NON-C	O	VFORI	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	· ·	ř		 	DISPOSITION				AGAINST DE			
	0.				Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T			Descri	iption of work order update	1	nitial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							·	CODY				
	· · · · · · · · · · · · · · · · · · ·					AUL	T CATE	GORY				
Landin	Cracks Crushed Cuffs Heat Tre Inspection	on Strip ir n Bend	1 Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete, enance eled d	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Torque \	Naves in:	Extrusior	1	Drawing	1	[Out of (Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

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Work Order ID: 100158

D4030-041

Parent Item Name: Long Basket Assembly (350)

100158 *D4030-041*

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Parent Item:

Purchased

No

Each

100

1.878.000

**

NAS1149F0432P

Washer

<u>Location</u>	Loc Q	<u>ty</u>	Loc Code		
ST295	18	78			
122151		2			
123522		4			
123900	1	72			
124580	4	00			124880
124859	. 3	00			75
125268	10	00			
	100	Each	728.0000	4	4 ~

NAS1149F0563P

Purchased

Purchased

No

No

**

NAS1149F0563P

Washer

Location	Lo	c Oty	Loc Code
ST295		728	
121350		7 <u>2</u> 8	
	100	Each	8,690.000

**

NAS1149F0332P

WASHER

NAS1149F0332P

Location	1	Loc Oty	Loc Code
GA		182	
	122063	182	
ST294		158	
	122063	158	
ST295		3	
	123352	3	
st510		8347	
	123900	8347	

		1							DQA:	Date:					
NCR: Y	es / No	1			WORK ORDER NON-	CONFO	QA Closed:	Date:	A						
Work Orde	r:	1			DISPOSITION		AGAINST DEPARTMENT/PROCESS								
	0.	:			Rework Scrap Use-as-is	The	Skid-tube Machining ermoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR N	0.				Work Order Update]	Large Fab	Composite]	Supplier					
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initia Chief E	1	Action scription	Sign & Date Verification		QC Inspector				
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	- Janes - Jane	3.00	cty	-											
onapproved [· · · · · · · · · · · · · · · · · · ·	<u> </u>			F	AULT CA	TEGORY								
Landin	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Crimped at n Strip in n Bend Vaves in E lequence	Tube Extrusion		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Insp Instr Mai Misl Misr Offs Out	lware ection Incomplete uctions Incomplet ntenance abeled ead et of Calibration of Sequence		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	ct sissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other				
	Wave/Tw	ist in Tul	эе		Folio	Out	side Dimensions								

Picklist Print

April-18-13 1:19:58 PM

Work Order ID: 100158

Parent Item:

D4030-041

NAS1149C0432R

Parent Item Name: Long Basket Assembly (350)

Purchased

100158

No

D4030-041

122441

Start Date: 4/18/13

Required Date: 5/02/13

Page 9

2

2

Required Qty: 1.00

Start Qty: 1.00

**

1,686.000

NAS1149C0432R

Washer

Location Loc Qty Loc Code ST292 1686 119124 6

1680

Each

												DQA:	Da	te:			
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																	
												QA Closed:	Da	te:			
West Order						DISPOSITION					INST DEPARTMENT/PROCESS						
Work Order:						Rework	Skid-tube Crosstube			٦	Water Jet			Engineering			
Part No.						Scrap	1	Machining Small Fab				Prod. Eng. Coor.			Quality		
	•					Use-as-is	`			Finishing	Rec/Store/Packaging Othe				Other		
NCR I	No.									Composite	site Supplier						
							_				_	4	· · · · · · · · · · · · · · · · · · ·				
Root					ľ	ption of work order update	1	Initial Action			ļ	Sign &			061		
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desci	ription	4	Date	Verificatio	n	QC Inspector		
Doc/Data	Ш																
Equip/Tooling	Ш																
Operator	Ш																
Material											1						
Setup					;												
Other							1				ł						
Process	Ш			,		•											
Supplier											1						
Training	Ш																
Unapproved			<u> </u>	<u> </u>													
FAULT CATEGORY																	
Landing Gear General										Γ-	_] _a / ₅ /		
	-	Bending				Bend	_	Grain			_	Ovalized		-	Pressure/Forced		
	Centre Not Concentric to O/S					BOM/Route	_	Hardware			-	Over/Under		-	Temperature/Cure		
	\vdash	Cracks			<u></u>	Broken/Damaged	<u> </u>	Inspection Incomplete			-1	Part Incorre		<u></u>	Weld		
	Ш	Crushed/	Crimped.			Burrs	L	Instructions Incomplete/Unclear			-	Part Lost/Mi	issing		Wrong Stock Pulled		
	Cuffs					Contamination		Maintenance				Part Moved					
	Heat Treat					Countersink		Mislabeled			_	Positioned V	_	_	7		
		Inspectio	n Strip in	Tube		Cut Too Short	L	Misread				Power Loss/	Surge	L	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish







